

## **AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the present application:

## **LISTING OF CLAIMS:**

1. (Previously Presented) A liquid-cooled casting die for continuous billet casting comprising:

a form-giving casting die body (1) having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and at least one of running closer to the pouring surface, being configured narrower, and being spaced closer to each other in at least one portion of the die body.

2. (Previously Presented) The casting die body (1) as recited in claim 1, wherein the form-giving casting die body is made of copper or a copper alloy.

3. (Previously Presented) The casting die body (1) as recited in claim 1, further comprising a die cavity (2) defined by two broad-side walls situated opposite each other and two narrow-side walls, the narrow-side walls forming a cross-section of the die cavity.

4. (Previously Presented) The casting die body (1) as recited in claim 3, wherein the cross-section of the die cavity (2) at a first end is greater than at a second end.

5. (Previously Presented) The casting die body (1) as recited in claim 3, wherein the broad-side walls further define a funnel running from the first end to the

second end and the at least one portion of the die body including sides of the funnel.

6. (Previously Presented) The casting die body (1) as recited in claim 5, wherein the at least one portion extends to cover an area that is at least 20% more than the sides of the funnel.

7. (Previously Presented) The casting die body (1) as recited in claim 5, wherein the at least one portion extends to cover an area that is 30-60% more than the sides of the funnel.

Claims 8 to 9. (Cancelled).

10. (Currently Amended) The casting die body (1) as recited in claim ~~[[1]]~~ 12, wherein the cooling channels (4) run deeper in the at least one portion of the die body such that the thickness separating the pouring-surface from the cooling-surface is reduced in the said at least one portion of the die body.

11. (Previously Presented) The casting die body (1) as recited in claim 10, wherein the thickness is reduced by 1 to 6 mm.

12. (Previously Presented) The casting die body (1) as recited in claim 1, wherein the cooling surface comprises a plurality of cooling channels (4).

Claim 13. (Cancelled).

14. (Previously Presented) The casting die as recited in claim 12, wherein the cooling channels are narrower on both sides of the funnel.

15. (Previously Presented) The casting die as recited in claim 12, wherein the cooling bore holes are arranged between the cooling channels (4).

16. (Currently Amended) A liquid-cooled casting die for [[a]] continuous billet casting comprising:

a form-giving casting die body (1) having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and being spaced at least 20% closer to each other in at least one portion of the die body, wherein the broad-side walls define a funnel having sides, the at least one portion of the die body including the sides.

**AMENDMENTS TO THE DRAWINGS:**

The attached sheets of drawings includes changes to Figures 3 and 4. These sheets, which include Figures 1 to 5, replaces the sheet including Figures 1 to 5 submitted on January 29, 2004. Figure 3 has been amended to include reference number 14 for the bore holes and to show more clearly the varying size of the bore holes, the varying spacing between the bore holes 14 and the varying spacing of the bore holes to the cooling surface along the width of the casting die. Figure 4 has been amended so as to narrow the cooling grooves relative to those in Figure 5. No new matter has been added.

Attachment: Two (2) Replacement Sheets